



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBW6305G16231-3G-1

Job Sheet 172405



2/11/18

Part No: RBW6305G16231-3G-1

Job Qty: 3 ea

Part Name: Handle



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/16/18

Job Tracking No:

Due Date: 4/16/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBW6305G16231-3G Rev 2 IPP Rev A 18.02.15 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	3 pcs		4/16/18	0.00	0.00	Purchasing		At 19/04/18
110	Packaging	3 pcs		4/16/18	0.00	0.00	Packaging2		At 19/04/18
120	QC	3 pcs		4/16/18	0.00	0.00	QC6		38
130	Packaging	3 pcs		4/16/18	0.00	0.00	Packaging3		18-04-17
140	QC21-FG	3 Ea		4/16/18	0.00	0.00	QC21	18/04/18	GA0916

Part Op 100 - Issue PO to ARROW TECH MACHINE WORKS P/O: 039084 MANUFACTURE RBW6305G16231-3G-1 AS
Descriptions: PER DWG -Certificate of conformity is required

FEB 22 2018

DAS

21

9-00

APR 18 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBW6305G16231-3G-1P	Handle	3 (1 ea)	100-Purchasing	5061465

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	RBW6305G16231-3G-1P	3	0	0

Part Specifications

Specifications could not be found.

Plex 2/16/18 9:44 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



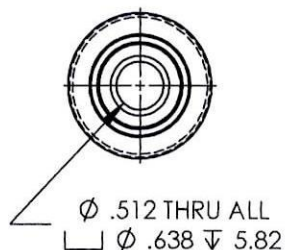
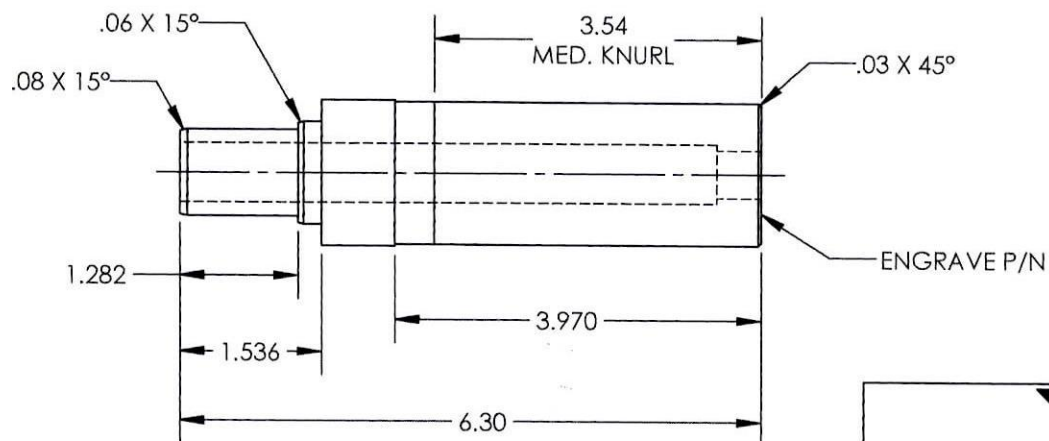
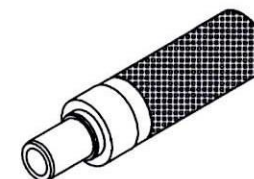
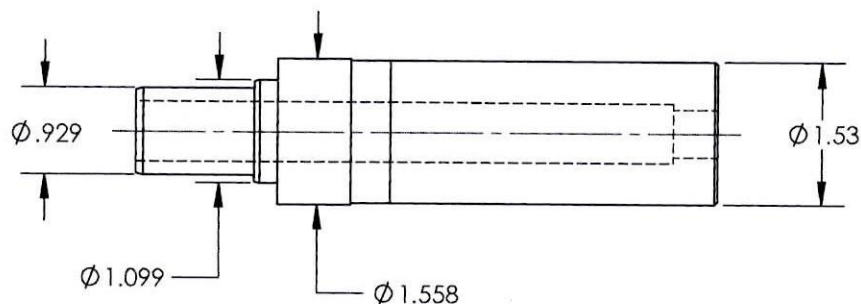
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																																																	
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval																																																																															
Description Work Order Deviation			Disposition																																																																																
Job No: 172405 Mfg Date: 04/16/18 Packaging Change No: Operation: Revision: Serial No/Batch: S061497 PART NO: RBW6305G16231-3G-1 Handle			Completed By																																																																																
			Lead hand / Supervisor Approval Verification																																																																																
			QC / QA Coordinator Approval																																																																																
<table border="1" style="width:100%; border-collapse: collapse;"> <thead> <tr> <th colspan="6" style="text-align: left;">Root Cause</th> </tr> </thead> <tbody> <tr> <td>Environment</td><td>☐</td> <td>No Re-verification</td><td>☐</td> <td>Crushing</td><td>☐</td> </tr> <tr> <td>Design</td><td>☐</td> <td>Operator</td><td>☐</td> <td>Heat Treat</td><td>☐</td> </tr> <tr> <td>Doc/Data</td><td>☐</td> <td>Offset/Setup</td><td>☐</td> <td>Wave/Twist in Tube</td><td>☐</td> </tr> <tr> <td>Equip/Tooling</td><td>☐</td> <td>Supplier</td><td>☐</td> <td>Marks/Chatter</td><td>☐</td> </tr> <tr> <td>Handling/Pre</td><td>☐</td> <td>Training</td><td>☐</td> <td>Cut Too Short</td><td>☐</td> </tr> <tr> <td>Material</td><td>☐</td> <td>Use for Testing</td><td>☐</td> <td>Instructions Incomplete/Unclear</td><td>☐</td> </tr> <tr> <td>Internal Transport</td><td>☐</td> <td>Poor Information</td><td>☐</td> <td>Drill Holes</td><td>☐</td> </tr> <tr> <td>Tribal Knowledge</td><td>☐</td> <td>Rushing</td><td>☐</td> <td>Fit/Function</td><td>☐</td> </tr> <tr> <td>LOA</td><td>☐</td> <td>Product Improvement</td><td>☐</td> <td>Misaligned/off center</td><td>☐</td> </tr> <tr> <td>Substation</td><td>☐</td> <td>Process Improvement</td><td>☐</td> <td>Turning Sequence</td><td>☐</td> </tr> <tr> <td>Past Expiry Date</td><td>☐</td> <td>Manufacturing Process</td><td>☐</td> <td></td><td></td> </tr> <tr> <td>Misidentified</td><td>☐</td> <td>Past Due</td><td>☐</td> <td>OTHER :</td><td></td> </tr> </tbody> </table>						Root Cause						Environment	☐	No Re-verification	☐	Crushing	☐	Design	☐	Operator	☐	Heat Treat	☐	Doc/Data	☐	Offset/Setup	☐	Wave/Twist in Tube	☐	Equip/Tooling	☐	Supplier	☐	Marks/Chatter	☐	Handling/Pre	☐	Training	☐	Cut Too Short	☐	Material	☐	Use for Testing	☐	Instructions Incomplete/Unclear	☐	Internal Transport	☐	Poor Information	☐	Drill Holes	☐	Tribal Knowledge	☐	Rushing	☐	Fit/Function	☐	LOA	☐	Product Improvement	☐	Misaligned/off center	☐	Substation	☐	Process Improvement	☐	Turning Sequence	☐	Past Expiry Date	☐	Manufacturing Process	☐			Misidentified	☐	Past Due	☐	OTHER :	
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REVISIONS			
REV	ECR	DESCRIPTION	DATE
			INITIAL
			APPROVED



(-1)

HANDLE

DART AEROSPACE	
TITLE TOOL, FAN/ECS DRIVE QUILL LIP SEAL INSTALLER	
DWG NO. RBW6305G16231-3G-1	REV 2
MAT'L 6061	DRAWN BY: CLOUGH
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± .5° .X ± .1	APPROVED <i>D Weil</i>
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	HEAT TREAT FINISH CLEAR ANODIZE
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	SPEC MIL-A-8625F, TYPE II, CLASS I USED ON MODEL AW139
SCALE 1:2	DATE 2/4/2011
SHEET 2 OF 3	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					



Dart Aerospace Ltd.
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K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO039084

Items											
Line Item	Part	Supplier Part No	Item No	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
				3G Rev. 1							
Line Item Note job# 172416											
15	RBW6305G14631-3GP			Tail Rotor Drive Quill Seal Housing Remover As Per Dwg RBW6305G14631-3G Rev. 1A	Firmed	4/16/18	3 Ea	0 Ea	3 Ea	\$1,205.32/Ea	\$3,615.96
Line Item Note job# 172415											
16	RBW6305G14831-3GP			Tail Rotor Drive Quill Lip Seal Remover As Per Dwg RBW6305G14831-3G Rev. 2	Firmed	4/16/18	3 Ea	0 Ea	3 Ea	\$922.80/Ea	\$2,768.40
Line Item Note job# 172414											
17	RBW6305G16031-3GP			Drive Quill Seal Housing Remover As Per Dwg RBW6305G16031-3G Rev. 2	Firmed	4/16/18	3 Ea	0 Ea	3 Ea	\$981.65/Ea	\$2,944.95
Line Item Note job# 172413											
18	RBW6305G18331-3GP			Ecs Drill Quill Lip Seal Remover As Per Dwg RBW6305G18331-3G Rev. B	Firmed	4/16/18	3 Ea	0 Ea	3 Ea	\$534.40/Ea	\$1,603.20
Line Item Note job# 172412											
19	RBW6305G18631-3GP			Ecs Drive Quill Housing Remover As Per Dwg RBW6305G18631-3G Rev. 2	Firmed	4/16/18	3 Ea	0 Ea	3 Ea	\$1,043.33/Ea	\$3,129.99
Line Item Note job# 172411											
20	RBW6305G19231-3GP			Puller Rotor Brake Adapter Flange Remover As Per Dwg RBW6305G19231-3G Rev. 2	Firmed	4/16/18	3 Ea	0 Ea	3 Ea	\$740.19/Ea	\$2,220.57
Line Item Note job# 172410											
21	RBW6305G19151-3GP			Guide Fan Drive Quill Seal Housing Installer As Per Dwg RBW6305G19151-3G Rev. B	Firmed	4/16/18	3 Ea	0 Ea	3 Ea	\$132.32/Ea	\$396.96
Line Item Note job# 172402											
22	RBW6305G16231-3G-1P			Handle As Per Dwg RBW6305G16231-3G-1 Rev. 2	Firmed	4/16/18	3 Ea	0 Ea	3 Ea	\$368.38/Ea	\$1,105.14



ARROW TECH MACHINE WORKS

Certificate of Conformance

Your Purchase Order No:039084

Dated: 4/12/2018

Our Order / Job No:11AWT

Order Qty:3

Part Name: HANDLE & SEAT

Part Number: RBW6305G16231-3G

Lot Size:N/A

Ship Date: 4/12/2018

We certify that these parts shipped to you are of domestic or international manufacture and conform to all requirements of the Purchase Order. These parts have been manufactured and inspected in accordance with all required specifications, instructions and drawings. Any applicable specifications are listed below:

Drawing Number:RBW6305G16231-3G Rev:2

Material Size and Type: -1/6061 ALUM, -3/6061 ALUM

Material Specifications:ALUMINUM - ASTM B221

Heat Treatment:N/A

Plating/Finish: CLEAR ANODIZE -MIL-A-8625F, TYPE II, CLASS I

Mercury Contamination: The material used to process this order has not come in contact with mercury or mercury bearing instruments.

Date: 4/12/18

Signed: Herbert M. Fink

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